




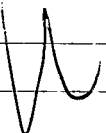




Work Order ID 64564

Wednesday, December 08, 2010 10:26:57 A


Page 1

Item ID:	D3286-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Spacer				Stop	
Start Date:	12/8/2010	Start Qty:	30.00		Cust Item ID:	
Required Date:	12/22/2010	Req'd Qty:	30.00		Customer:	
Reference:						


Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr								
D3286	Rev A								

100		0.00							
	Hardinge CNC LATHE SMALL					32	0		
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn blanks as per Folio FA434 and Dwg D3286 Deburr as [per Dwg D3286								

SA 10/12/21

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
						32	0		
QC	Memo	0.00							
Quality Control									

SA 10/12/21

120	QC8- Inspect parts - second check	0.00							
						31	0		
QC	Memo	0.00							
Quality Control									

SA 10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64564

Wednesday, December 08, 2010 10:26:57 A

Page 2

Item ID: D3286-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 12/8/2010 Start Qty: 30.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location LG

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

32 0 3E11/01/04

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/05
MK

11-01-04

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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 08, 2010 10:27:01 AM

Page 1

Work Order ID: 64564

Parent Item: D3286-3

Parent Item Name: Spacer




Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A 04.07.14 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			110	f	188.5977	0.3417	10.79053			
													
304 RD Tube .500 x .049W													

Location

Loc Qty

Loc Code

MAT

172.7647378

114676

11.9789478

115010

160.78579

MAT017

15.833

111814

15.833

SA 10/12/21

~~12/12/21~~ 12/12/21

W/O:		WORK ORDER CHANGES					
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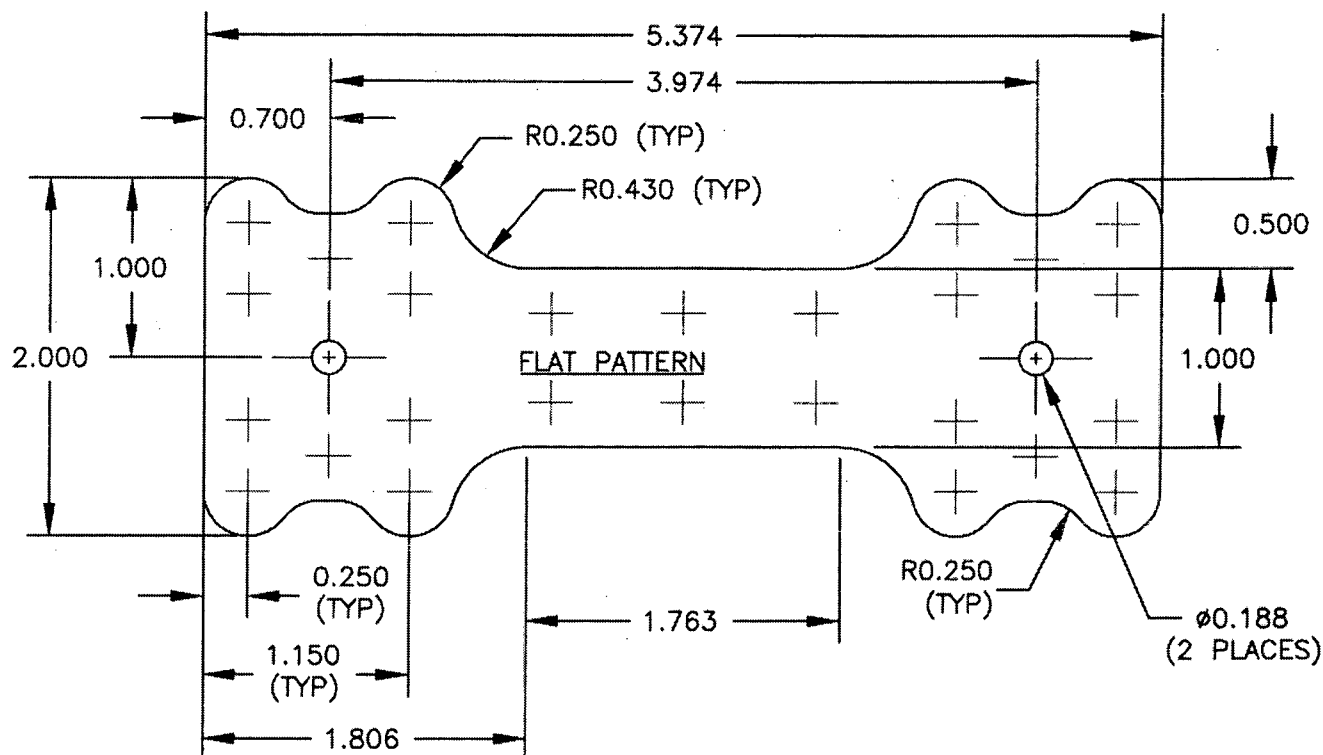
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



BENDING DETAIL

R1.51

RELEASED
04.06.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *041564*

25-0-12-8

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

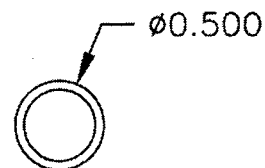
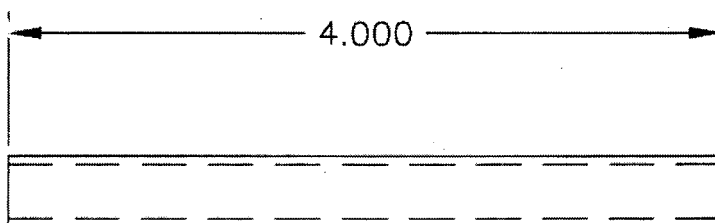
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



w/o 64569

D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TRO.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *CP*

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